

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018916**Date Inspected:** 25-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. M. Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # TRIAL ASSEMBLY YARD (Lift 11E)

This QA Inspector along with QA Inspector Mr.Manjunath S Math performed dimensional survey inspection on the bike path cantilever to verify the length of cantilever, distance from end of cantilever to nearest anchor bolt and spacing between anchor bolts using measuring tape. The measurements were recorded on a separate sheet and forwarded to team leader for review and disposition. The segment, panel point and bike path cantilever designations are as follows:

11AE – PP 95 - BK001-048

11AE – PP 97 - BK001-049

11BE – PP 99 - BK001-050

11CE – PP 101 - BK001-003

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (12AE)

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 018 in the (2F)

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

horizontal position on deck panel I stiffener piece mark no. DP3001-001. The location was the hold back of WT stiffener fillet weld of segment 12AE at crossbeam side. The welder ID was 040378. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-4114-1.

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 031 in the (2F) horizontal position on deck panel I stiffener piece mark no. DP3011-001. The location was the hold back of WT stiffener fillet weld of segment 12AE at bikepath side. The welder ID was 040270. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-4114-1.

For additional information please reference the pictures below:

OBG # TRIAL ASSEMBLY YARD (12BE)

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 012 in the (2F) horizontal position on deck panel I stiffener piece mark no. DP3012-001. The location was the hold back of WT stiffener fillet weld of segment 12BE at crossbeam side. The welder ID was 040378. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-4114-1.

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 007 in the (2F) horizontal position on deck panel I stiffener piece mark no. DP3022-001. The location was the hold back of WT stiffener fillet weld of segment 12BE at bikepath side. The welder ID was 040270. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-4114-1.

OBG # TRIAL ASSEMBLY YARD (12AE)

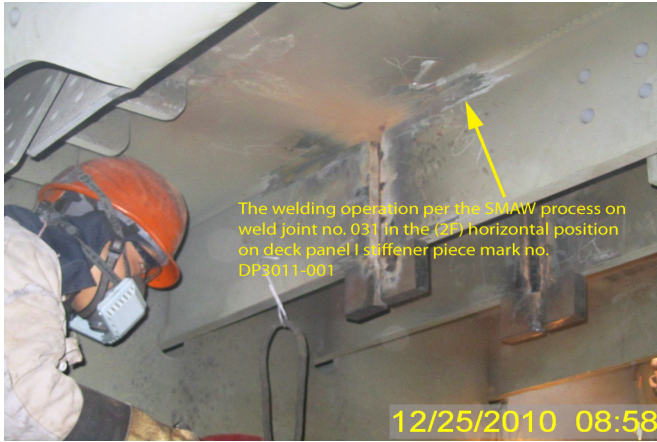
The QA Inspector observed the welding operation per the SMAW process on weld joint no. 028 in the (4G) overhead position on longitudinal shear plate piece mark no. DP3005-001. The location was the complete joint penetration groove weld joining the longitudinal shear plate with the deck panel of segment 12AE at crossbeam side. The welder ID was 050289. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-Tc-U4b-FCM-1.

OBG # TRIAL ASSEMBLY YARD (12BE)

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 009 in the (4G) overhead position on longitudinal shear plate piece mark no. DP3016-001. The location was the complete joint penetration groove weld joining the longitudinal shear plate with the deck panel of segment 12BE at crossbeam side. The welder ID was 050289. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-Tc-U4b-FCM-1.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan,Murugan	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
